Work Order ID 79614
January-30-12 11:33:15 AM

79614

Item ID: D4436-043
Revision ID:
Item Name: Aft Outboard Bracket Assembly

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 30/01/2012 **Start Qty:** 2.00 *2*
Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** M.L.J **Date:** 12/01/30 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D4436	A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut D4436-1 as per Dwg Dwg Rev: A Prog Rev: 1 2-Deburr if necessary	0.00 0.00				B12-1-30			(2)
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				B12-1-30			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79614

January-30-12 11:33:15 AM

79614

Item ID: D4436-043

Revision ID:

Item Name: Aft Outboard Bracket Assembly

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 30/01/2012 **Start Qty:** 2.00 *2*

Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 S 12/01/30				(+2)			
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00 SB 12/01/31				(2)			
140 *140* Small Fab Small Fab	Memo C"SINK AS PER DWG	0.00 0.00							12/01/31 (2)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** __________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79614
January-30-12 11:33:15 AM

79614

Item ID: D4436-043
Revision ID:
Item Name: Aft Outboard Bracket Assembly

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 30/01/2012 **Start Qty:** 2.00 *2*
Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals:	**Process Plan:**	**Date:**	**Tooling:**	**Date:**
	QC:	**Date:**	**SPC (Y/N):**	**Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 S 12/01/31				2			
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2		BK	12-1-31.
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	∅		M 12/01/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79614

January-30-12 11:33:15 AM

79614

Item ID: D4436-043 | Accept | *N900040100* | Setup Start *NS1* | Stop *NS2*

Revision ID:

Item Name: Aft Outboard Bracket Assembly

Start Date: 30/01/2012 **Start Qty:** 2.00 *2*

Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1* | Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Small Fab Small Fab	 **Memo** Assemble as per dwg. do not install rubber seal.	0.00 0.00							12/01/31 (2)
185 *185* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00							12-01-31 (2)
190 *190* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 **Memo** START TIME: 9:30 OVEN TEMPERATURE: 320 °F FINISH TIME: 10:00	0.00 0.00							2x ø M- 12/01/31

M115128

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79614
January-30-12 11:33:15 AM

79614

Item ID:	D4436-043	Accept	*N900040100*
Revision ID:		Setup Start	*NS1*
Item Name:	Aft Outboard Bracket Assembly	Stop	*NS2*
Start Date:	30/01/2012	**Start Qty:** 2.00	*2*
Required Date:	31/01/2012	**Req'd Qty:** 2.00	*2*
Cust Item ID:		**Customer:**	
Reference:			

Approvals:	**Process Plan:**	**Date:**	**Tooling:**	**Date:**	Run Start	*NR1*
	QC:	**Date:**	**SPC (Y/N):**	**Date:**	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	BL 12-1-31.		
202 *202* Small Fab Small Fab	Memo Install rubber seal as per dwg 3M 1300 batch: H100225	0.00 0.00	S8 12/01/31			②			
205 *205* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 12/01/31			②			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79614 *79614*

January-30-12 11:33:15 AM

Item ID: D4436-043 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Aft Outboard Bracket Assembly

Start Date: 30/01/2012 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** Date: **Tooling:** Date: Run Start *NR1*

QC: Date: **SPC (Y/N):** Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: 5'1.1 Memo	0.00 0.00					C12/1/31		2
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/1/31

12-01-31 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-30-12 11:33:19 AM

2

Work Order ID: 79614 *79614*

Parent Item: D4436-043 *D4436-043*

Parent Item Name: Aft Outboard Bracket Assembly

Start Date: 30/01/2012 **Required Date:** 31/01/2012

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP REV:B
12.01.24 PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 *M6061T6S.040* 6061-T6 .040 Sheet		Purchased	No			100	sf	319.4100	1.59 **	3.347368	B 12-1-30		
MS20426AD3-2 *MS20426AD3-2* Rivet		Purchased	No			180	Each	18,319.00	4 **	8	12/01/31		
MS21075L08 *MS21075L08* ANCHOR NUT		Purchased	No			180	Each	71.0000	2 **	4	12/01/31		

M6061T6S.040 locations:

Location		Loc Qty	Loc Code	
MAT021		319.41		
	113004	2.5		
	117653	40.91		
	120154	95.5		120154
	120218	180.5		

3 12.01.31

PTO

MS20426AD3-2 locations:

Location		Loc Qty	Loc Code
Mezz		18319	
	1173	8919	
	13276	9400	

M119/09 (8)

MS21075L08 locations:

Location		Loc Qty	Loc Code	
ST303		3		
	111578	3		
ST304		68		
	120121	68		4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
120431		PERMANENT CHG: MS20426AD3-3 IN LIEU OF MS20426AD3-2				120431	

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ______

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-30-12 11:33:19 AM

Work Order ID: 79614 — *79614*

Parent Item: D4436-043 — *D4436-043*

Parent Item Name: Aft Outboard Bracket Assembly

Start Date: 30/01/2012 **Required Date:** 31/01/2012

Start Qty: 2.00 **Required Qty:** 2.00

D4441-1	Manufactured	No	202	f	35.4840	1.408	2.816

D4441-1
Rubber Seal

**

SB 12/01/31

Location		Loc Qty	Loc Code
prelim		35.484	
	74760	35.484	

2.816

cut qty 1 to 16.00"

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

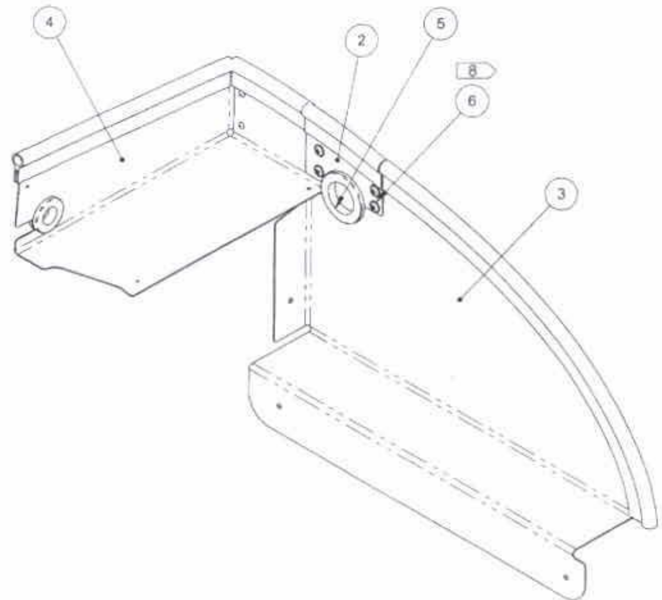
Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



79614 M.L.J
12/01/30

2012-01-23

D4436-041 AFT BRACKET ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 1.31 lbs
8) TORQUE SCREW TO 12-15 (in-lb)

REV	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	12.01.17

DESIGN	RF	DART AEROSPACE LTD, HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4436 — REV. A — SHEET 1 OF 7
MFG. APPR.		
APPROVED		TITLE: COVER ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	12.01.17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ________________ Disposition: ________________ QA: N/C Closed: __________ Date: _________

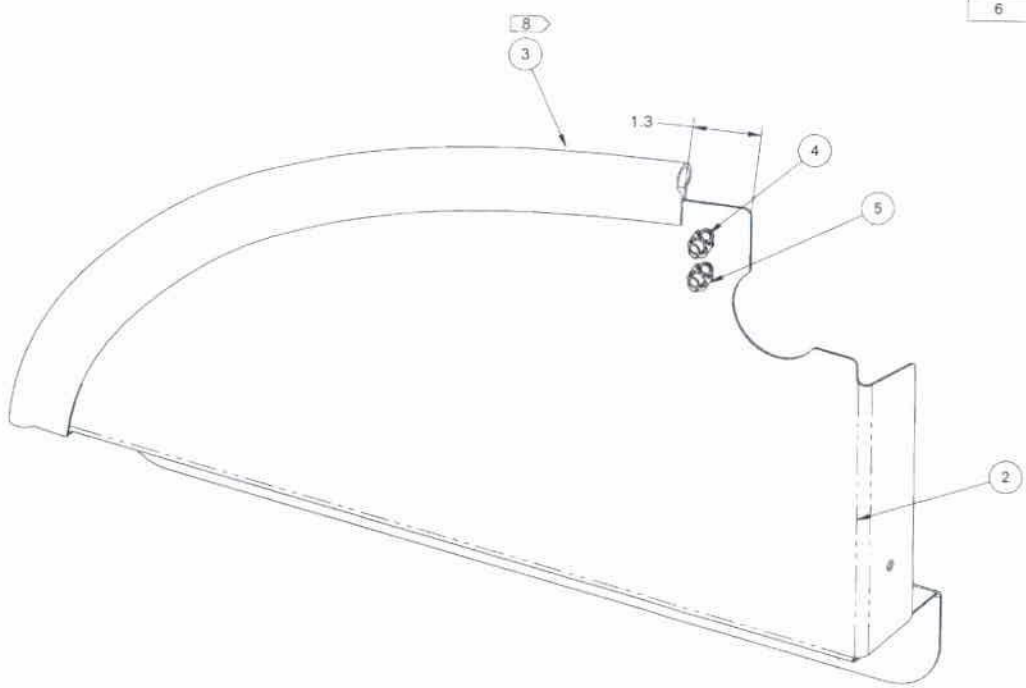
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79614

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-3	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE

A 12.01.31



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

2012 -01- 23

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.78 lbs
8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4436 REV. A SHEET 2 OF 7
CHECKED		
MFG. APPR.		
APPROVED		TITLE COVER ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.01.17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

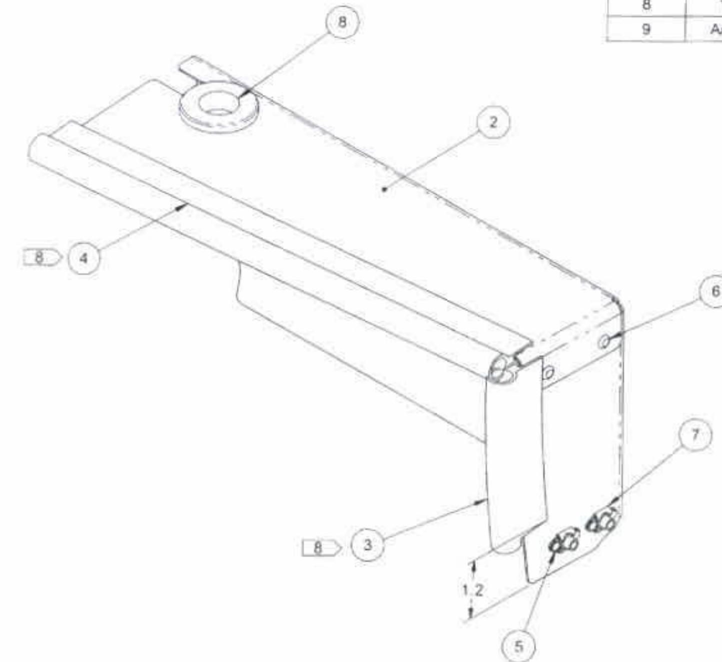
Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

73614

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-100	RUBBER SEAL
5	4	MS20426AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



D4436-045 AFT INBOARD BRACKET ASSEMBLY

RELEASE 2012-01-23

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs
8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE,
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4436 — REV. A — SHEET 3 OF 7
CHECKED	[signature]	
MFG. APPR.	[signature]	TITLE: COVER ASSEMBLY — SCALE NTS
APPROVED	[signature]	
DE APPR.	[signature]	
DATE	12.01.17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

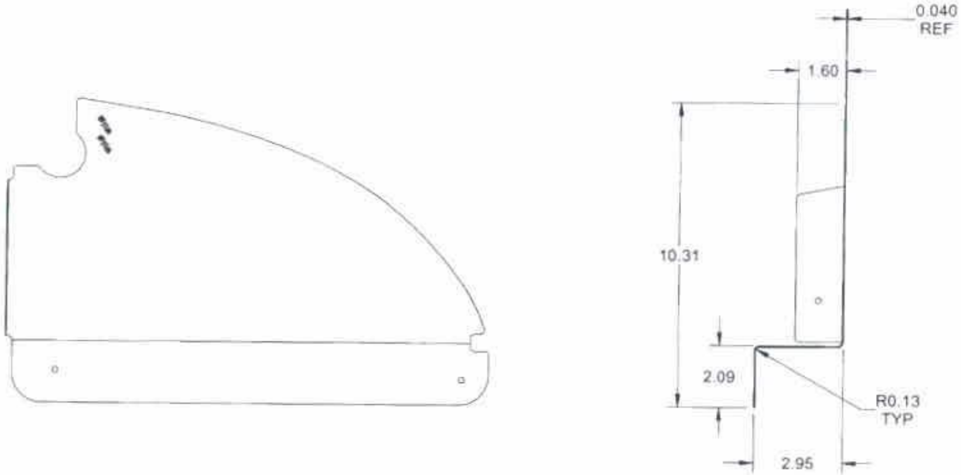
Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

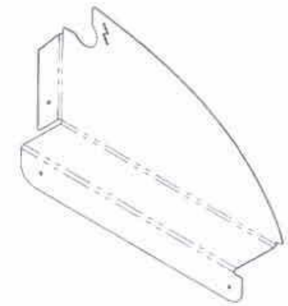
Resolution: ___________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79614





D4436-1 BRACKET

RELEASED 2012-01-23

NOTES:
1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4436 REV. A SHEET 4 OF 7
MFG. APPR.		
APPROVED		TITLE COVER ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.01.17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

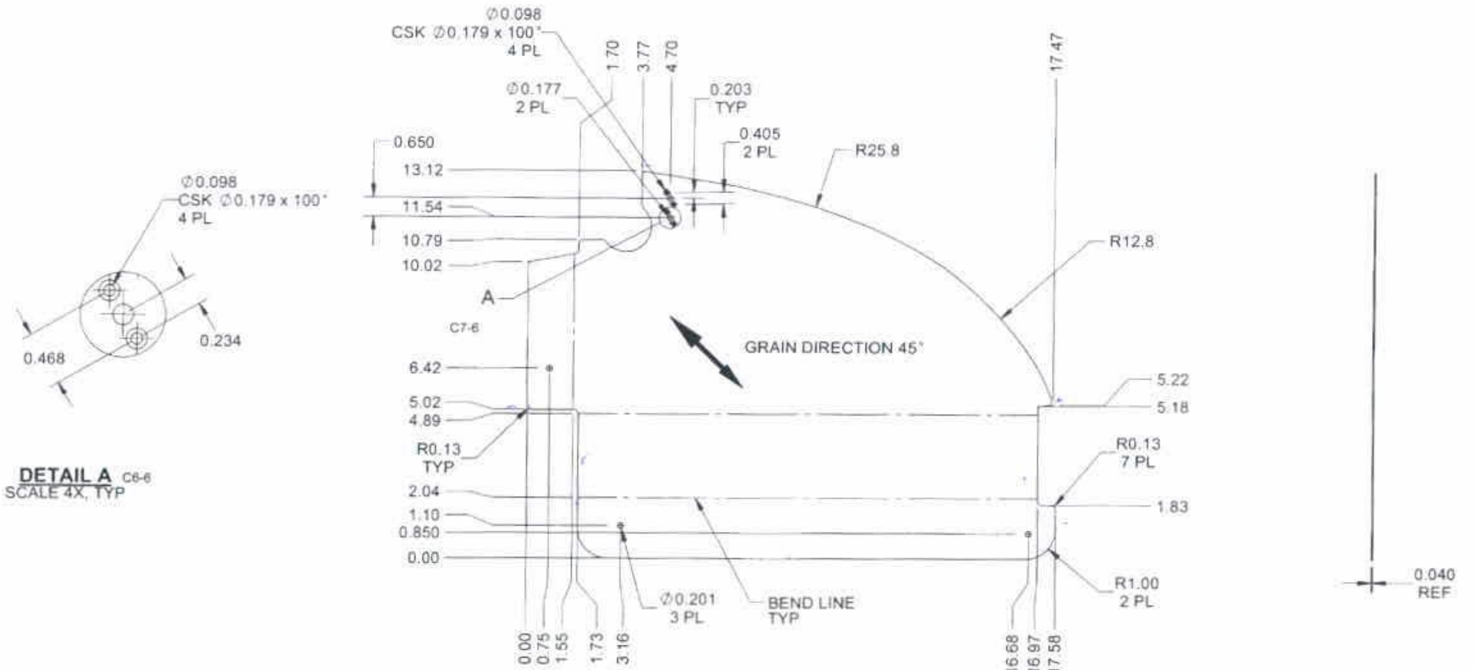
Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

79614



D4436-1F FLAT PATTERN

RELEASED 2012-01-23

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.69 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4436 — REV. A — SHEET 5 OF 7
CHECKED		TITLE COVER ASSEMBLY — SCALE NTS
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	12.01.17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

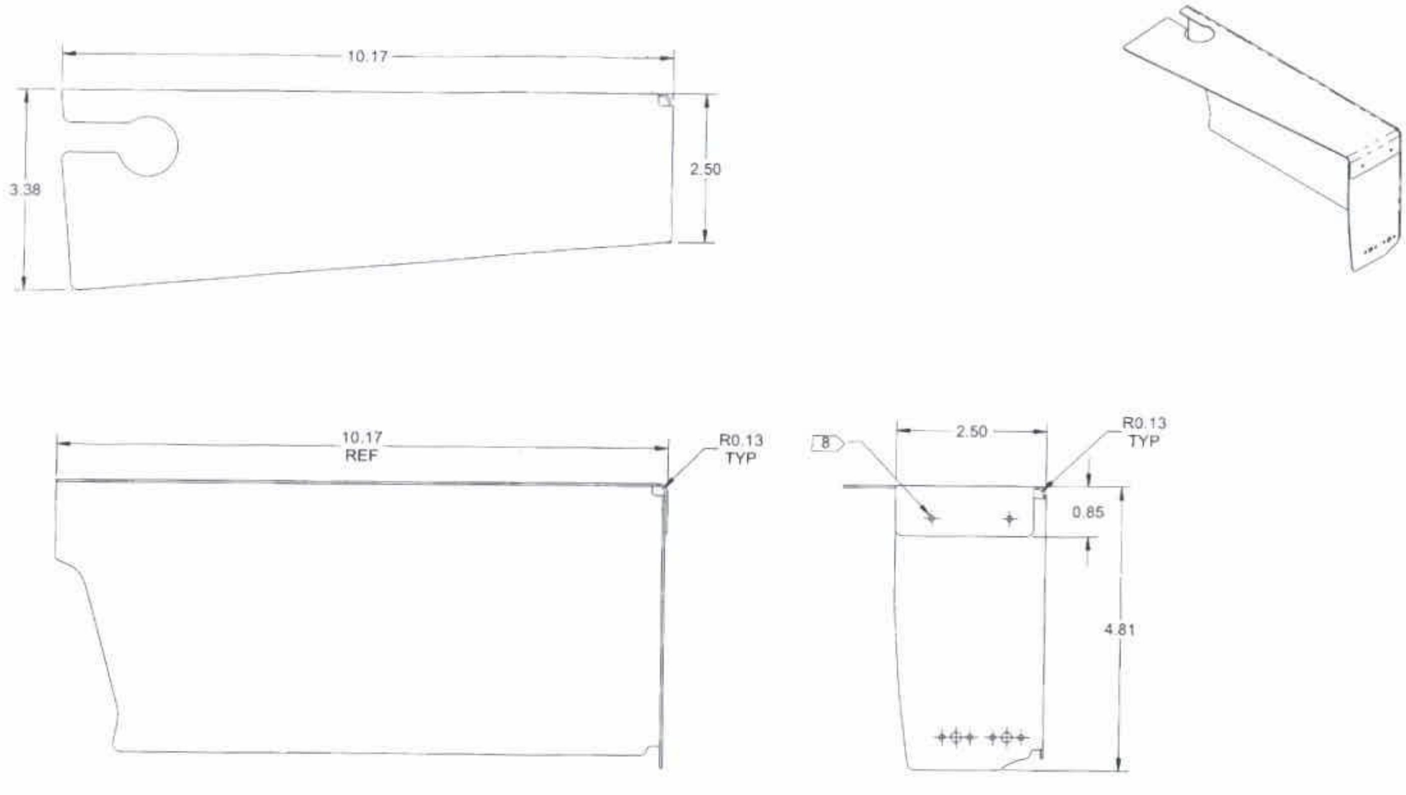
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: ____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79614



D4436-3 BRACKET

NOTES:
1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.33 lbs
8) TRANSFER ∅0.129 HOLES THRU 2 PLACES

DESIGN	RF
DRAWN	RF
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	12.01.17

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4436 — REV. A — SHEET 6 OF 7

TITLE: COVER ASSEMBLY — SCALE: NTS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

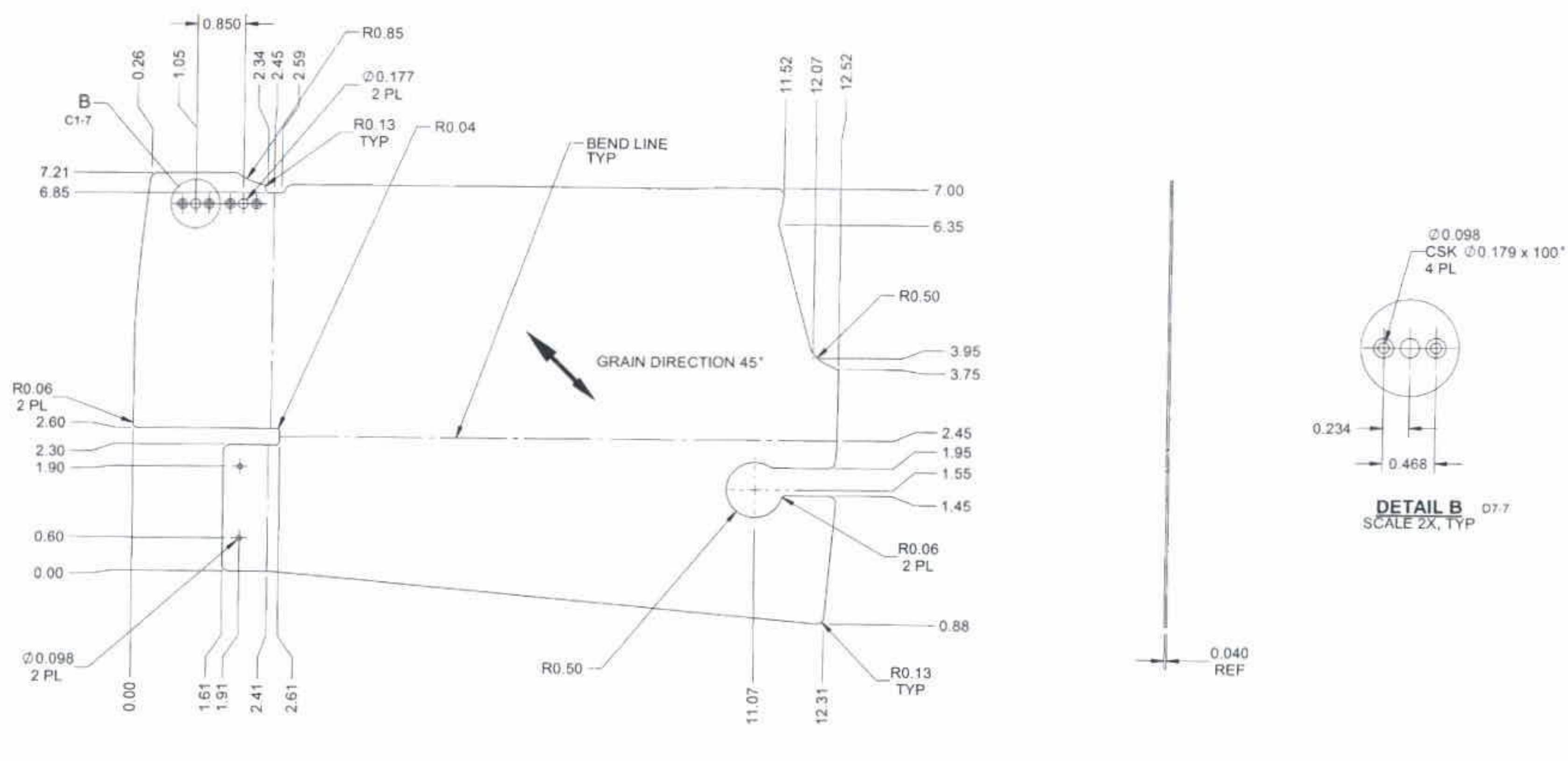
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79614



D4436-3F FLAT PATTERN

RELEASED 2012-01-23

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4436 — REV. A — SHEET 7 OF 7
MFG. APPR		
APPROVED		TITLE COVER ASSEMBLY — SCALE NTS
DE APPR.		
DATE	12.01.17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 79614
Description: AFT OUTBOARD BRACKET	Part Number: D4436-042
Inspection Dwg: D4436-1 . Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article   X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+.004 -.001	.101	2		V BG2	
Ø .177	+.005 -.001	.180	2		V	
Ø .201	+.005 -.001	.204	2		V	
.75	+/- .030	.747	2		V	
1.73	+/- .030	1.718	2		V	
3.16	+/- .030	3.156	2		V	
16.68	+/- .030	16.68	2		T BG1	
16.97	+/- .030	16.97	2		T	
17.58	+/- .030	17.58	2		T	
17.47	+/- .030	17.47	2		T	
4.70	+/- .030	[illegible] 698	2		V	
3.77	+/- .030	3.768	2		V	
1.70	+/- .030	1.699	2		V	
1.10	+/- .030	1.109	2		V	
5.02	+/- .030	5.026	2		V	
6.42	+/- .030	6.428	2		V	
11.54	+/- .030	11.533	2		T	
.650	+/- .010	.648	2		V	
13.12	+/- .030	13.12	2		T	
.040	+/- .010	.038	2		V	

Measured by: B	Audited by: S	Prototype Approval:
Date: 12-1-30	Date: 12/1/30	Date:

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	